

Work Order ID 150573

Friday, September 02, 2016 8:28:39 AM

150573

Page 1

Item ID: D350-591-123

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Heli-Access-Step™ LH - Low Gear, Short Step, Float Compatible

Start Date: 9/2/2016 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 9/2/2016 Req'd Qty: 1.00 ***1***

Customer:

Reference: re-inspect to current rev

Approvals: Process Plan: Date: Tooling: Date: Run Start ***NR1***QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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100

0.00

100

QC

Quality Control

MemoPULL FROM STK:
1 X D350-591-123 B9361
RE-INSPECT TO CURRENT REV.

ADD NEW/UPDATED PARTS A/R:

0.00

DAS
27
9-89

SEP 01 2016

110

0.00

110

Packaging

Packaging

Memo

ENSURE KIT IS COMPLETE

DART			
TRANSPORT CANADA APPROVAL # 09-89			
P/N	Heli-Access-Step	CHG	
DESC	D350-591-123	STC	SH92-6
LOT	B9361	STC	SH967NE
MODEL	AS350/355	STC	
US PATENT # 5735484		MADE IN CANADA	
CANADA FOREIGN PATENTS PENDING			

SEP 01 2016

Work Order ID 150573

Friday, September 02, 2016 8:28:39 AM

150573

Page 2

Item ID: D350-591-123 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Access-Step™ LH - Low Gear, Short Step, Float Compatible
Start Date: 9/2/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 9/2/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference: re-inspect to current rev

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120	QC4- 100% Inspect kits for completeness	0.00							
120									
QC	Memo	0.00							
Quality Control									
130	Identify as per dwg & Stock Location: _____	0.00							
130									
Packaging	Memo	0.00							
Packaging	RE-PACKAGE PER PPP USING NEW B/N NEW LABELS AND PAPERWORK REQ'D								
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.00							
Quality Control									

DAS
27
9-89

SEP 02 2016

DAS
27
9-89

SEP 02 2016

DAS
16
9-89

16/09/02

MNF
16-9-02

Picklist Print

Page 1

Friday, September 02, 2016 8:28:36 AM

Work Order ID: 150573

150573

Parent Item: D350-591-123

D350-591-123

Parent Item Name: Heli-Access-Step™ LH - Low Gear, Short Step, Float Compatible

Start Date: 9/2/2016

Required Date: 9/2/2016

Start Qty: 1.00

Required Qty: 1.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D350-591-123		Manufactured	No				Each	1.0000		1			

D350-591-123

Heli-Access-Step™ LH - Low Gear, Short Step, Float Compatible

Location

Loc Qty

Loc Code

Mezz

1

9361

1

BATCH #

D2230-1 DAS 27 9-89
D2230-3 DAS 27 9-89
D2732-030 DAS 27 9-89
AN337A DAS 27 9-89
AN4-13A DAS 27 9-89
AN4-16A DAS 27 9-89
NAS1149 D03635 DAS 27 9-89
NAS1149 D04635 DAS 27 9-89
MS21042L3 DAS 27 9-89
MS21042L4 DAS 27 9-89

X1 B146288 PC
X1 B146287 PC
X2 B149044 PC
X2 M134180 PC
X1 M135464 PC
X2 M135297 PC
X4 M134955 PC
X6 M135390 PC
X2 M135135 PC
X3 M135297 PC

Lon:

→ Will need a work order to pull B350-591-123
B9361 and inspect to current change number
(chg out). ID with new h#, new label and paper work.
Some thing with B350-591-124 B9361

Sylvain

→ inspect stop with bleu file and add any missing
parts.
Scrap and replace B2230-1/3 with new one
Record all changes on the back of the w/o.
Change stickers

P.D.

150573

150574

9362

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS D350-591 REV. G OR EARLIER
AND
INSTRUCTIONS OF CONTINUED AIRWORTHINESS ICA-D350-591 REV. 2 OR EARLIER

REF CANADIAN STC: SH92-6

REF FAA STC: SH967NE

For D350-591-121/-122/-123/-124/-133 steps, customers have the option of installing D2732-030 cushions under the D2230-1/-3 clamps to accommodate varying crosstube diameters and to improve fit. It is also acceptable to use longer or shorter AN4 bolts, and/or extra AN960JD416 washers under the nut to ensure 1.5 to 4 threads in safety. See Figure 1 on sheet 2 of this service instruction for reference.

For D350-591-121/-122 steps at CHG 005, D350-591-123/-124 steps at CHG 004, and D350-591-133 steps at CHG 003, the parts list of D350-591 Rev. G and ICA-D350-591 Rev. 2 is amended as follows:

ADD:

Qty -121	Qty -122	Qty -123	Qty -124	Qty -133	Part Number	Description
X					D350-591-121	<i>Heli-Access-Step</i> ™, Short Step – High Skid, LH
	X				D350-591-122	<i>Heli-Access-Step</i> ™, Short Step – High Skid, RH
		X			D350-591-123	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, LH
			X		D350-591-124	<i>Heli-Access-Step</i> ™, Short Step – Low Skid, RH
				X	D350-591-133	<i>Heli-Access-Step</i> ™, Aft Maintenance Step
2	2	2	2	8	D2732-030	CUSHION
2	2	2	2	8	AN4-16A	BOLT

The DSI-9459-011 kit is available for customers with earlier model D350-591-121/-122/-123/-124 steps. Longer AN4 bolts are provided to fasten the clamps. The DSI-9459-013 kit is available for customers with earlier model D350-591-133 steps.

Qty -011	Qty -013	Part Number	Description
X		DSI-9459-011	Rubber Cushion Kit (for -121/-122/-123/-124 steps)
	X	DSI-9459-013	Rubber Cushion Kit (for -133 steps)
2	8	D2732-030	CUSHION
2	8	AN4-16A	BOLT

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

BY: 
D. SHEPHERD (DE # 02)

DATE: 09.06.24
CERT. NO.: SH92-6
ISSUE NO.: 11

B	AN4-16A WAS -17A FOR -013/-133 KIT	CP	09.06.24
A	NEW ISSUE	CP	09.04.17
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		DSI 9459	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		OPTIONAL CLAMP MODIFICATIONS	NTS
DATE	09.06.24	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

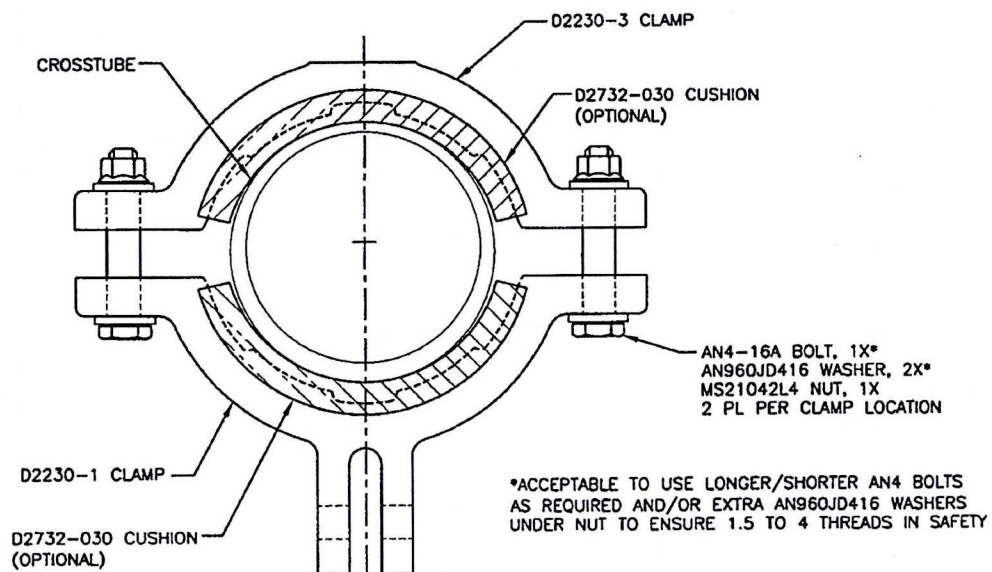


FIGURE 1: CLAMP DETAIL

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 09.06.24
CERT. NO.: SH92-6
ISSUE NO.: 11

DESIGN	92	DART AEROSPACE LTD	
DRAWN	92	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		DSI 9459	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		OPTIONAL CLAMP MODIFICATION	NTS
DATE	09.06.24	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

5.0 PARTS LIST

Qty -117A	Qty -119	Qty -133	Part Number	Description
X			D350-591-117A	<i>Hel-Access-Step</i> ™, Pre-Flight Step
	X		D350-591-119	<i>Hel-Access-Step</i> ™, Long Step – Low Skid
		X	D350-591-133	<i>Hel-Access-Step</i> ™, Aft Maintenance Step
	1		D2355	STEP ASSEMBLY (LOW-LONG)
		1	D2946-041	STEP ASSEMBLY (MAINTENANCE)
2	2		D2171	CLAMP
2	2		D2182B035	CUSHION
		4	D2230-1	MOUNTING LUG
		4	D2230-3	MOUNTING LUG
4	4		D2274	RADIUS BLOCK
1			D2362-041	SUPPORT BRACKET
	1		D2362-3	SUPPORT BRACKET
		1	D2945	MOUNTING PLATE
1	1		D3595-200-300	CUSHION
		8	D2732-030	CUSHION
	2		AN3-37A	BOLT
		2	AN4-7A	BOLT
		4	AN4-11A	BOLT
		8	AN4-16A	BOLT
	4		AN4-21A	BOLT
4	1		AN4-22A	BOLT
	4		NAS1149D0363J	WASHER (AN960JD10)
4	6	14	NAS1149D0463J	WASHER (AN960JD416)
	2		MS21042L3	NUT
4	5	14	MS21042L4	NUT

Qty -121	Qty -122	Qty -123	Qty -124	Part Number	Description
X				D350-591-121	<i>Hel-Access-Step</i> ™, Short Step – High Skid, LH
	X			D350-591-122	<i>Hel-Access-Step</i> ™, Short Step – High Skid, RH
		X		D350-591-123	<i>Hel-Access-Step</i> ™, Short Step – Low Skid, LH
			X	D350-591-124	<i>Hel-Access-Step</i> ™, Short Step – Low Skid, RH
1				D2351-041	STEP ASSEMBLY (HIGH-SHORT, LH)
	1			D2351-042	STEP ASSEMBLY (HIGH-SHORT, RH)
		1		D2356-041	STEP ASSEMBLY (LOW-SHORT, LH)
			1	D2356-042	STEP ASSEMBLY (LOW-SHORT, RH)
1	1	1	1	D2230-1	MOUNTING LUG
1	1	1	1	D2230-3	MOUNTING LUG
2	2	2	2	D2732-030	CUSHION
2	2	2	2	AN3-37A	BOLT
1	1	1	1	AN4-13A	BOLT
2	2	2	2	AN4-16A	BOLT
4	4	4	4	NAS1149D0363J	WASHER (AN960JD10)
6	6	6	6	NAS1149D0463J	WASHER (AN960JD416)
2	2	2	2	MS21042L3	NUT
3	3	3	3	MS21042L4	NUT